

Work Order ID 59603

Tuesday, June 08, 2010 2:24:27 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 6/8/2010 Start Qty: 1.00

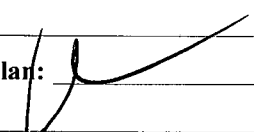


Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002 N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio ET009

2-Cut tubes as per Dwg. D2580

3-Scibe Batch # in Aft end of tube



Folio 016



10-6-14

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Revision ID:

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Item Name: Replacement Skidtube

Start Date: 6/8/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/0/6/15

① BE 19/06/15

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Item ID: D205-634-041

Accept

Revision ID:

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Start Date: 6/8/2010 Start Qty: 1.00

Required Date: 6/14/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod *m114242*

BE 10/06/16

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod *m114242*

BE 10/06/16

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

ALWM 10-06-17

Work Order ID 59603

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Item ID: D205-634-041

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Setup

Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 6/8/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

S. 10/06/17

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. 10/06/17

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd
cap out of solution.

27 10/06/28

1

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Item ID: D205-634-041

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 6/8/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M114841

11:45
320°
12:15

1 10-6-29

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M1 10/06/30

1 0

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Setup

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Item Name: Replacement Skidtube

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Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

0.00

=726 10/07/01

1

Ø

Hand Finishing

Memo

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

✓ A/R ☐ ☐ ☐ Sikaflex-291 ☐ M113519 ☐

Sikaflex expire date: 10/11

✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

✓ 3-Inspect for foreign object per QSI 024

✓ 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M113519 ☐

Sikaflex expire date: 10/11

✓ 5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 14114432

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Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

ML 10 *07* 01 *(1)*

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: *PPP 59280*

Rec'd 6/14/10 (1)

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

100707
MLF
10-7-6

Picklist Print

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Work Order ID: 59603

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 6/8/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1 Manufactured No 110 Each 8.0000



205 Skidtube bent detail

Location	Loc Qty	Loc Code
LG	3	
57028	1	
59143	2	
ST046	5	
58747	2	
58748	2	
59030	1	

Handwritten: 10-6-14

D2576-3 Manufactured No 140 Each 94.0000



Step (maching detail)

Location	Loc Qty	Loc Code
LG	94	
46661	46	
52215	48	

Handwritten: 1 BE 10/06/14

D2579 Manufactured No 140 Each 124.0000



Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	124	
57052	5	
57348	8	
58433	111	

Handwritten: 20 BE 10/06/14

Picklist Print

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Work Order ID: 59603



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 6/8/2010

Required Date: 6/14/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200 Each

88.0000

1

1



Cap

Location

Loc Qty

Loc Code

FP6

2

56613

2

ST026

86

50513

1

50770

28

51539

4

53791

53

x1 M 10/06/30

AN3-5A

Purchased No

200 Each

817.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST350

817

105057

817

x2 M 10/06/30

AN960JD10L

NAS1149D0332J Purchased

No

200 Each

3,795.000

2

2



Washer

Location

Loc Qty

Loc Code

ST348

3795

110985

3795

x2 M 10/06/30

ALS7-1032-130

Purchased No

200 Each

17.0000

50

50



Insert

Location

Loc Qty

Loc Code

ST282

17

113238

17

M14323

x50 M 10/06/30

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Required Date: 6/14/2010

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C4A	Purchased	No	200	Each	1,525.000	50	50
--------	-----------	----	-----	------	-----------	----	----

Location	Loc Qty	Loc Code
ST350	1525	
114103	501	
114108	14	
114416	12	
114523	2	
114859	996	

AN960C10L	Purchased	No	200	Each	0.0000	50	50
-----------	-----------	----	-----	------	--------	----	----

NAS1149C0332 R

x 50 M 10/06/30

D3566-13	Manufactured	No	200	Each	16.0000	1	1
----------	--------------	----	-----	------	---------	---	---

washer

x 50 M 10/06/30

Location	Loc Qty	Loc Code
FP	16	
53461	16	

D3566-5	Manufactured	No	200	Each	26.0000	1	1
---------	--------------	----	-----	------	---------	---	---

Gasket

x 1 M 10/06/30

Location	Loc Qty	Loc Code
FP015	26	
57682	4	
59158	22	

Gasket

x 1 M 10/06/30

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 6/8/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1	Manufactured	No	200	Each	29.0000	2	2
---------	--------------	----	-----	------	---------	---	---



Gasket * There was 2 left
 not 1

Location	Loc Qty	Loc Code
FP015	29	
57715	2	
58182	5	
59126	22	

X1 10/06/30

D3564-11	Manufactured	No	200	Each	3.0000	1	1
----------	--------------	----	-----	------	--------	---	---



Wearshoe

Location	Loc Qty	Loc Code
FP019	3	
59021	3	

X1 10/06/30

D3564-13	Manufactured	No	200	Each	10.0000	1	1
----------	--------------	----	-----	------	---------	---	---



Wearshoe

Location	Loc Qty	Loc Code
FP17	10	
57922	10	

X1 10/06/30

D3564-9	Manufactured	No	200	Each	5.0000	1	1
---------	--------------	----	-----	------	--------	---	---



Wearshoe

Location	Loc Qty	Loc Code
FP	1	
55334	1	
FP019	4	
57958	4	

X1 10/06/30

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 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 6/8/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 200 Each 24.0000 1 1
 Wearshoe

Location	Loc Qty	Loc Code
FG	1	
34806	1	
FP19	11	
57525	1	
58709	10	
FP-19	12	
59157	12	

x1 10/06/30

D2594-3 Manufactured No 200 Each 111.0000 16 16
 O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code
FP	111	
55546	19	
58191	92	

B59358

x10 10/06/30

D2594-1 Manufactured No 200 Each 326.0000 16 16
 Plug, 205 Skidtube

Location	Loc Qty	Loc Code
FP	190	
42807	112	
55002	71	
57826	7	
FP14	136	
58434	136	

x7

x9

> 10/06/30

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Shop Packet Print

Page 5

DART**RELEASED**
07-06-28 #

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A MEMORANDUM
WITHOUT NOTICE
WORK ORDER
NO. 59403
P/10-6-08

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28

Diagram illustrating the underside of the D2576-3 step, showing the locations for grinding and the location ridge on the underside of the D2576. The diagram includes labels for:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Diagram illustrating the rear view of the cap assembly. The diagram shows the cap with the bolt and washer installed. The following components and dimensions are labeled:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-291
- AN3-SA BOLT (1)
- AN96QD10L WASHER (1)
- (2 PLACES)
- D2855 CAP
- 0.40

Diagram illustrating the assembly of a propeller hub, showing the following components and instructions:

- D2579 SPACER**: Indicated by a leader line pointing to the top of the hub.
- D2596 WEB (REF)**: Indicated by a leader line pointing to the central web of the propeller.
- AL57-1032-130 (REF) (TYP 50 PLACES)**: Indicated by a leader line pointing to the bottom of the hub.

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

Figure 1 is an elevation view of the road cross-section. It shows the road profile, the drainage ditch, and the bridge structure. The road width is 11.0. The ditch width is 1.4. The bridge width is 32.0 ± 1.0. The distance between the hole and the tangent point is 1.0. The road profile is labeled with '4' and '20.0'.

Technical drawing of a ship's hull section, showing various components and dimensions. The drawing includes a side view of the hull and a cross-sectional view of the hull structure.

Dimensions and Labels:

- 0.5 (Dimension)
- 1.5 (Dimension)
- 1.5 (Dimension)
- D (Dimension)
- 8 (Triangle symbol)
- 1.5 (Dimension)
- 1.5 (Dimension)
- 1.5 (Dimension)

Textual Labels:

- BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE
- BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE
- WELD AS PER DETAIL B
- REFER TO DETAIL C
- D3566-1
- D3566-5
- D3566-1
- D3566-13
- D3564-11
- D3564-5
- D3564-9
- D3564-13
- AN3C4A BOLT (1)
- AN950C10L WASHER (1)
- (5D PLACES)

Table:

DESIGN	DATE	DRAWN BY

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DART		DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA	
DRAWING NO. D2580		REV. 0 SHEET 2 OF 3	
TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

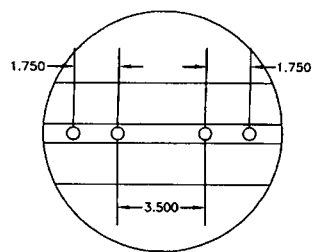
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

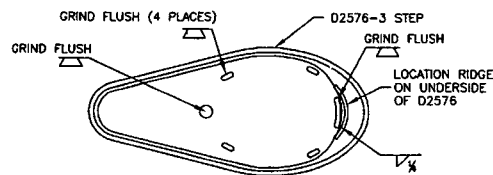
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

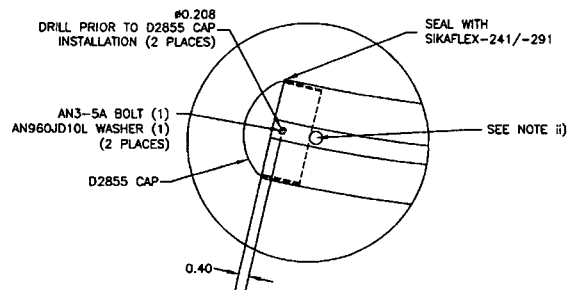


DETAIL F
SCALE 5:24

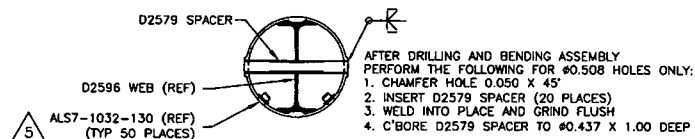


RELEASED
07 Dec 78

DETAIL G
SCALE 5:24



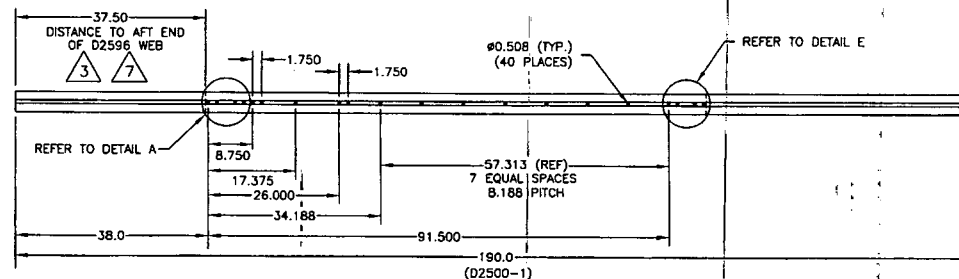
SECTION H-H
SCALE 5:24



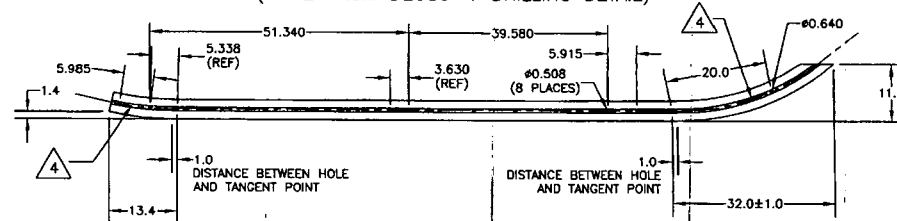
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

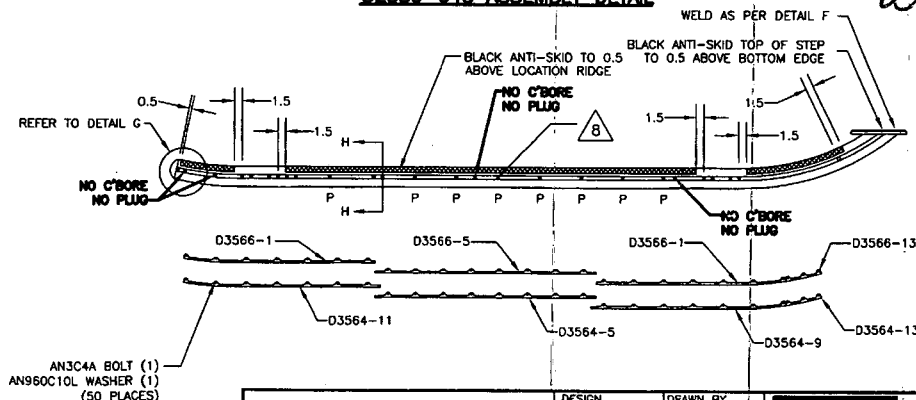
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. WARRICKSLEY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE, ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 232

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bailey Elliott
Job number: 59105
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dunn Date of Test Coupon 10.06.01

Welder Bailey Elliott Date of Test Coupon 10.06.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld